

Work Order ID 76818***76818****Rush*

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Monday, November 21, 2011 1:10:35 PM

Item ID: D2617-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 11/21/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/21/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 11-11-21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2617

Rev D2

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA437 and Dwg D2617

*SA 11/11/22**10 0*

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SA 11/11/22**10 0*

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*SA 11/11/22**10 0*

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Hand Finishing

Work Order ID 76818

76818

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Item ID: D2617-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 11/21/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/21/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: ST020

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MF 11-11-21

MF 11-11-21

11/22/2011

Picklist Print

Monday, November 21, 2011 1:10:34 PM

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Work Order ID: 76818
Parent Item: D2617-3
Parent Item Name: Bushing

Start Date: 11/21/2011 Required Date: 11/21/2011
Start Qty: 10.00 Required Qty: 10.00

Comments: IPP G04.07.14Reformat; added step 5KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 6061-T6 RD Tube .375 x.058W		Purchased	No			100	f	1,253.8460	0.0729	0.7673684			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT014	1253.846	
116920	0.578	
119087	17.268	
119376	504	
119644	432	
119678	300	

11/21/22
1 Root

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

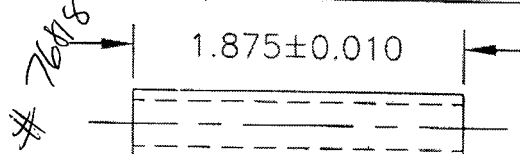
NOTE: Date & initial all entries

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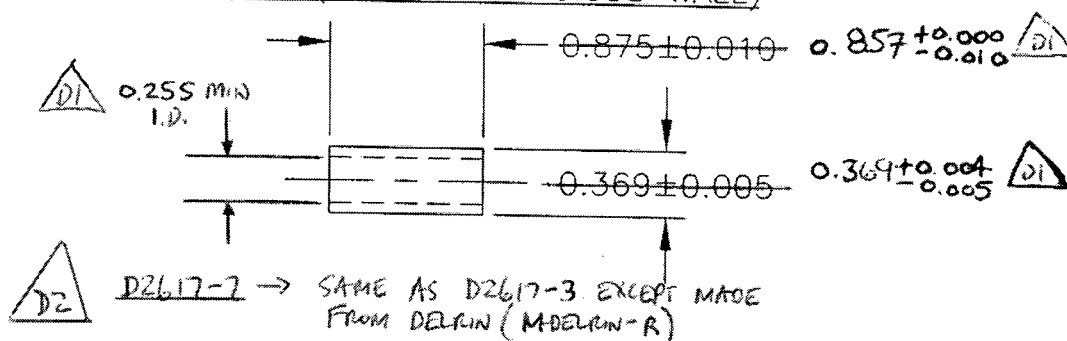


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
D2	04.04.10	#	CP	ADD D2617-7	
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
D1	04.07.12	#	CP	CORRECT TOLERANCE (NCR 779)	

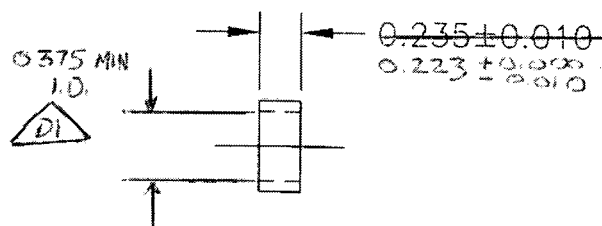
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NOTE: Date & initial all entries

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